



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3582-1-BENT
Job Sheet 193007



Part No: D3582-1-BENT

Job Qty: 8 pcs

Part Name: Skidtube Assembly BK117



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/5/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3582 page 1 REV.E SHEET 1 IPP REV:A 14.01.17 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	8 pcs	4/12/19	4/12/19	0.00	1.79	Skidtubes - Bend		M6v6
120	QC 5	8 pcs	4/12/19	4/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	8 pcs	4/12/19	4/12/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S171127



Part: D3582 - 1 - BENT

Job No: 193007

Serial No/Batch: S171127

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/10/19

P.T.O.

					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	BE
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	8 pcs	4/12/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - (CNC Delta 100 Bender) Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3, use bending
Descriptions: aid DT9632 2- cut fwd end of tube as per dwg
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: LCM2) LOCATION : LG002
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2962-150	3.540 Outer Tube, Extrud	8 pcs (1 ea)	110-Skidtubes - Bend - 1	5084714

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2962-150	8	14	0

Part Specifications

Specifications could not be found.

ITEM	Qty	Part Number	Description
	X	D3582-041	SKIDTUBE ASSEMBLY
1	1	D2862-150	EXTRUSION
2	1	D2864	CAP
3	1	D2865	CAP
4	1	D2971	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3568-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3594-1	WEB
14	3	D3662-1	CROSS BOLT SPACER
15	1	D3662-3	CROSS BOLT SPACER
16	2	D5004-1	CROSS BOLT SPACER
17	2	D5620-1	DOUBLER
18	28	AN9C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-1A	BOLT
21	28	NAS1148C0332R	WASHER (AN960C10L)
22	2	NAS1148D0332J	WASHER (AN960JD10L)
23	2	NAS1148D0416J	WASHER (AN960JD16L)
24	38	AELS-1032-130	INSERT
25	2	AL57-428-165	INSERT
26	88	CR3212-3-05	CSK RIVET, CHERRY MAX

- NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3564-1 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
ANTI-SKID PAINT AS INDICATED TO 1.00" ABOVE CENTER LINE PER DART QSI 005 4.4.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 18.2 lbs
8) WELDING: PER DART QSI 004.
9) INSERT D3564-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SHAKFLEX-241/281 ADHESIVE PER DART QSI 015 AFTER BENDING.
10) USE DART DRILL TEMPLATE DTR800 TO LOCATE AND DRILL Ø0.287 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SHAKFLEX-241/281.
11) DO NOT INSTALL AN3C4A BOLTS AND NAS1148C0332R WASHERS IN INDICATED LOCATIONS
12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5620-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10308. COUNTERSINK Ø0.288 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5620-1 DOUBLER USING QTY (34) CR3212-3-05 CSK RIVETS.

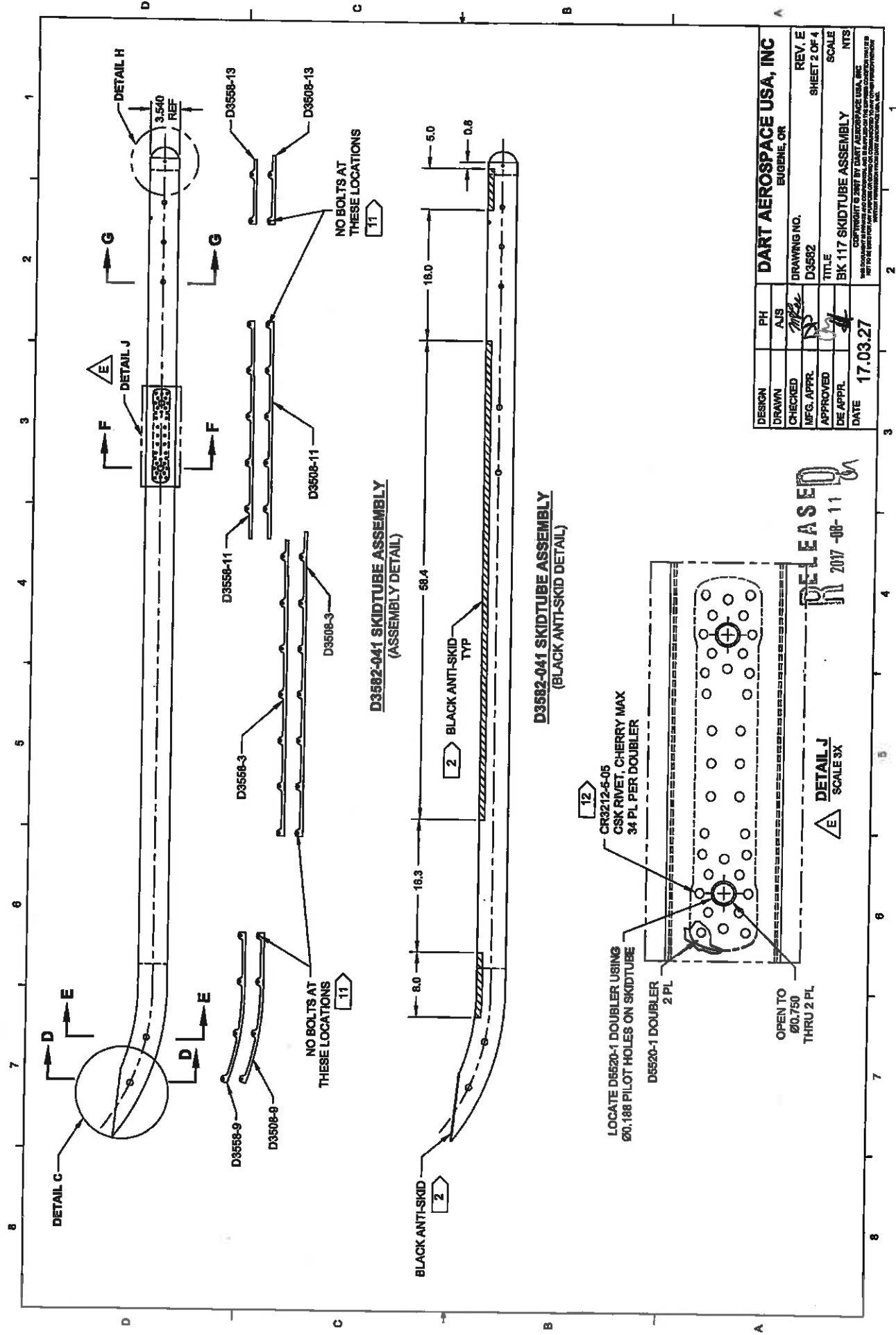
RELEASED
2017-08-11
EW 17-547

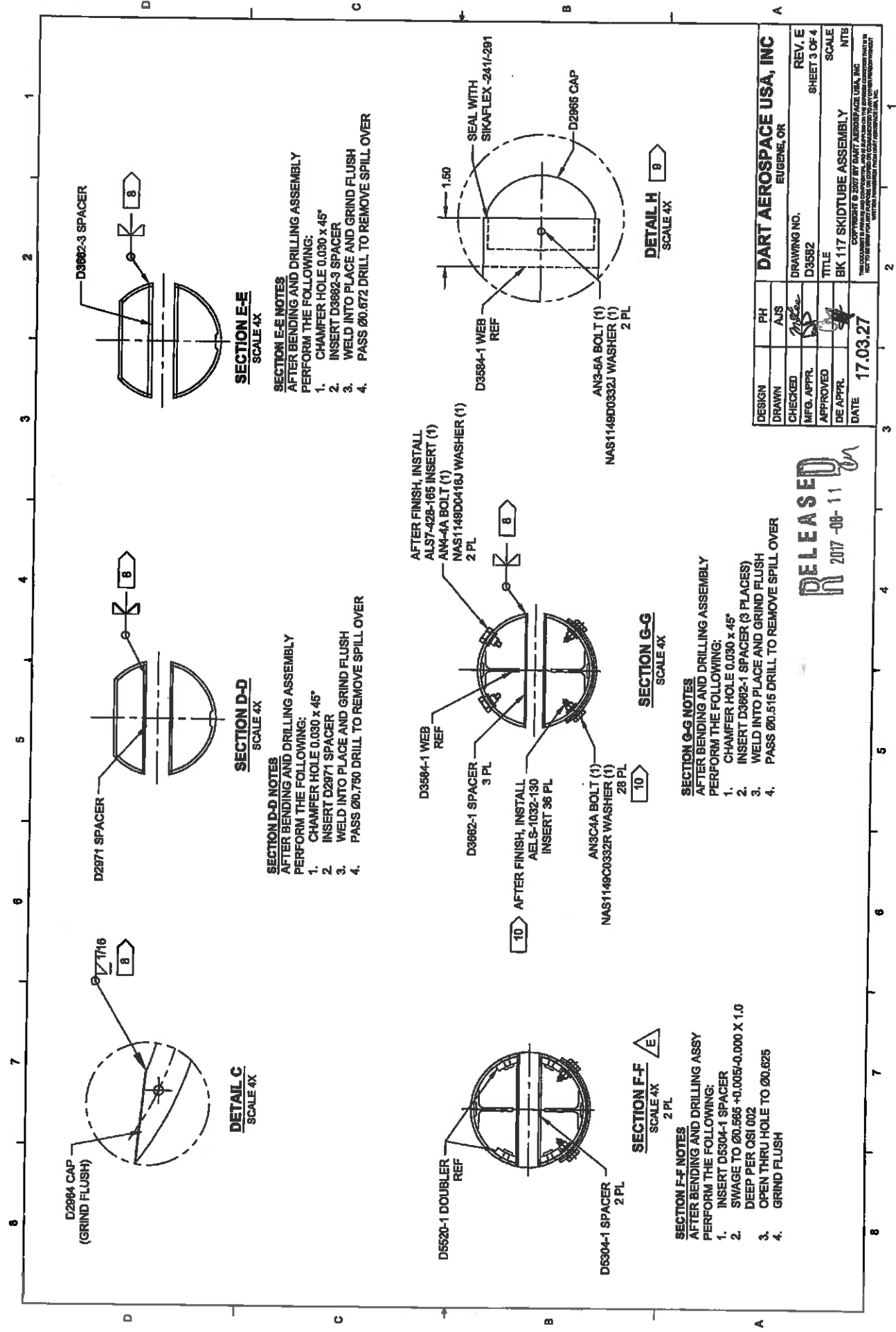
E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. Ø0.161 HOLE WAS Ø0.175. ADD SHT 3, ADD DETAIL J. SECTION F-F ADD D5620-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D3504-1 WAS D2973; REVISE BOM & SECTION F-F & SECTION NOTES (ZN B7-3, A2-3); REF NCR19-6180	RF	17.01.09
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	16.11.02
B	29.88 WAS 29.87 (ZN C2-1). INCORPORATED DED D3582A-1 (ZN D5-1). FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	AJS	
DRAWN	AJS		
CHECKED	PH		
MFG. APPR.	D3582	DRAWING NO.	
APPROVED		TITLE	REV. E
DE APPR.		BIK 117 SKIDTUBE ASSEMBLY	SCALE
DATE	17.03.27		NTS

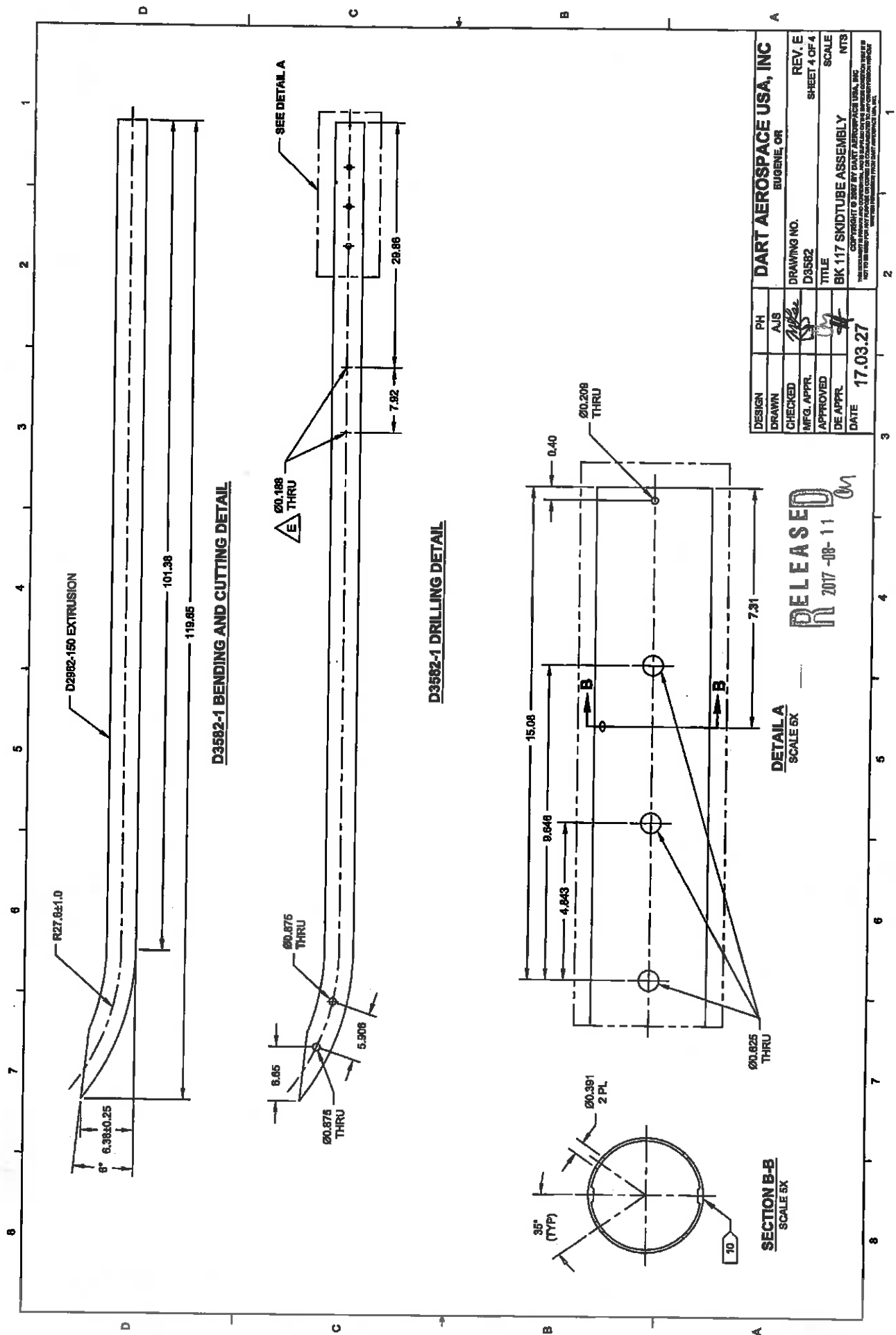
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DRAWN	AJS	RUGENE OR
CHECKED		DRAWING NO.
MFG. APPR.		D3592
APPROVED		TITLE
DE APPR.		BK 117 SKIDTUBE ASSEMBLY
DATE	17.03.27	SCALE
		NTS

RELEASED
2017-08-11

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
								Completed By			
								Lead hand / Supervisor			
								QC / QA Coordinator			



md
20-jun-2019

NCR No. 19-7218		Job: 19007 193007		Part No. D3582-1 BENT													
Date: APR 10 2019		Sequence #: 120 QCS		QTY Affected: 1													
Description Work Order Deviation		Disposition															
~ ONE TUBE UNDERBENT. PART IS ALREADY CUT, CAP DOES NOT FIT.		- SCRAP															
Root Cause		FAULT CATEGORY															
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☒ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
DISPOSITION		DEPARTMENT/PROCESS															
Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube ☒ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐															
MRB (QSI042)		MRB (QSI042)															
12 QCS		12 QCS															
19-04-10		19-04-10															
19-04-10		19-04-10															
QC / QA Coordinator		QC / QA Coordinator															
DAS 68 9-89		DAS 68 9-89															
APR 10 2019		APR 10 2019															